

303 R-345

Work Order ID 77090

77090

Page 1

November-25-11 10:53:46 AM

Item ID: D3393-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Cam Lock Shaft

Start Date: 25/11/2011 Start Qty: 8.00 *8*

Required Date: 09/12/2011 Req'd Qty: 8.00 *8*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: M.L.S Date: 11/11/25 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3393	Rev A								

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn as per Folio FA509 and Dwg D3393 Machine D3393-3 as per Folio FA509 and Dwg D3393 Identify as D3393-3 Debur

12-02-06

20

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

12-02-06

120

120

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA509 and Dwg D3393

12/02/08

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77090

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Item ID: D3393-3 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Cam Lock Shaft
Start Date: 25/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 09/12/2011 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>12/02/08</i>			<i>20</i>			
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>12.2.8</i>			<i>20</i>	<i>1</i>		
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>12/45</i>						

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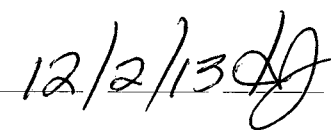
Page 3

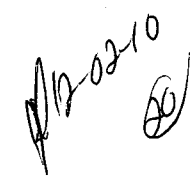
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>091</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/2/13 

12-02-10 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-25-11 10:53:50 AM

Page 1

Work Order ID: 77090

77090

Parent Item: D3393-3

D3393-3

Parent Item Name: Cam Lock Shaft

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.02.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R0.375		Purchased		No		100	f	25.1510	0.1167	0.982737			
------------	--	-----------	--	----	--	-----	---	---------	--------	----------	--	--	--

M303R0 375

**

303 Round Bar 0.375"

12-02-06

Location

Loc Qty

Loc Code

MAT028

25.151

115806

1.711

115868

23.44

1.983 2.5

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FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	12-02-06	Date:	3-2-8	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	

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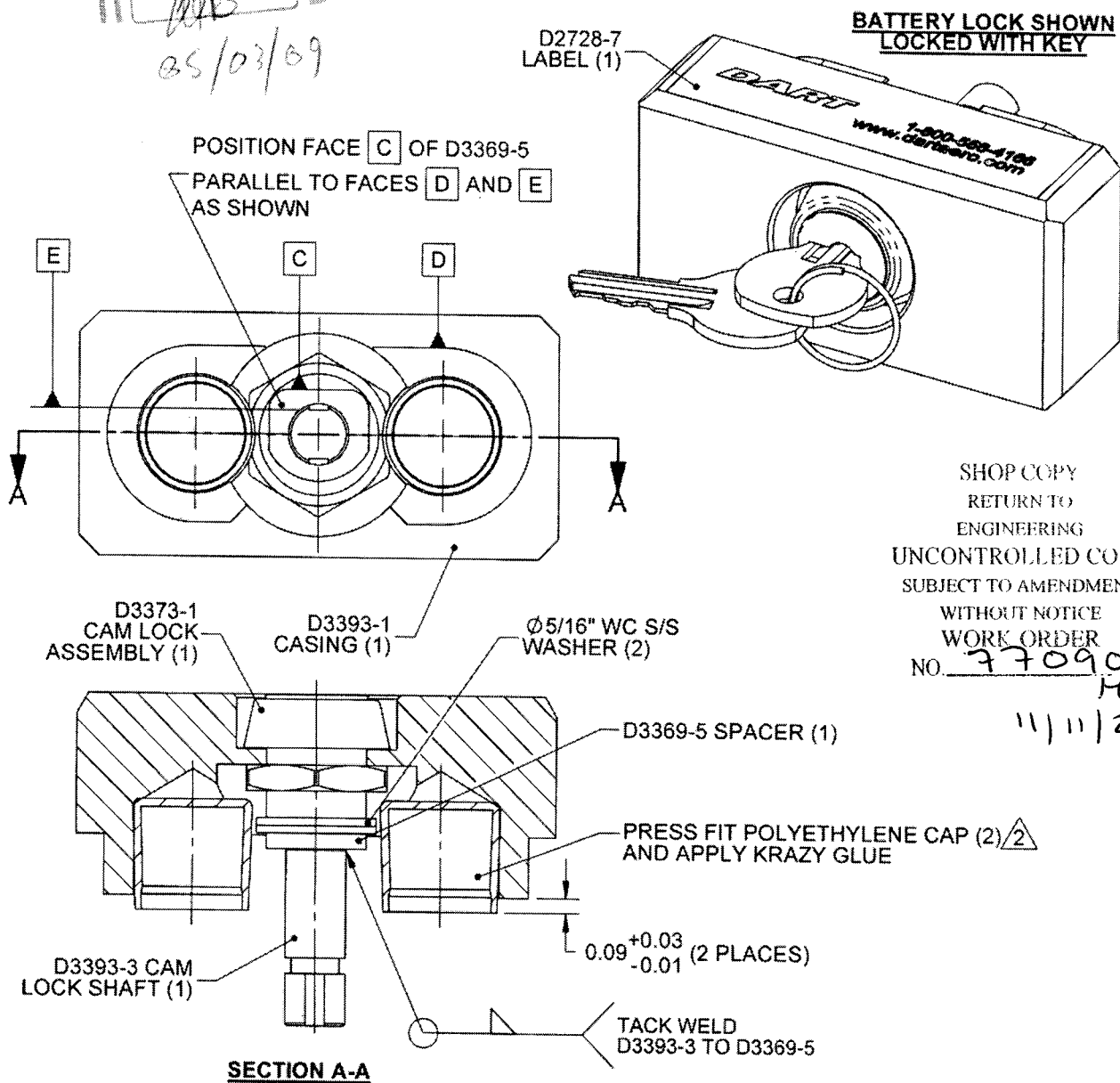
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]
05/03/09



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **77090**
H.C.J.
11/11/25

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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Dart Aerospace Ltd

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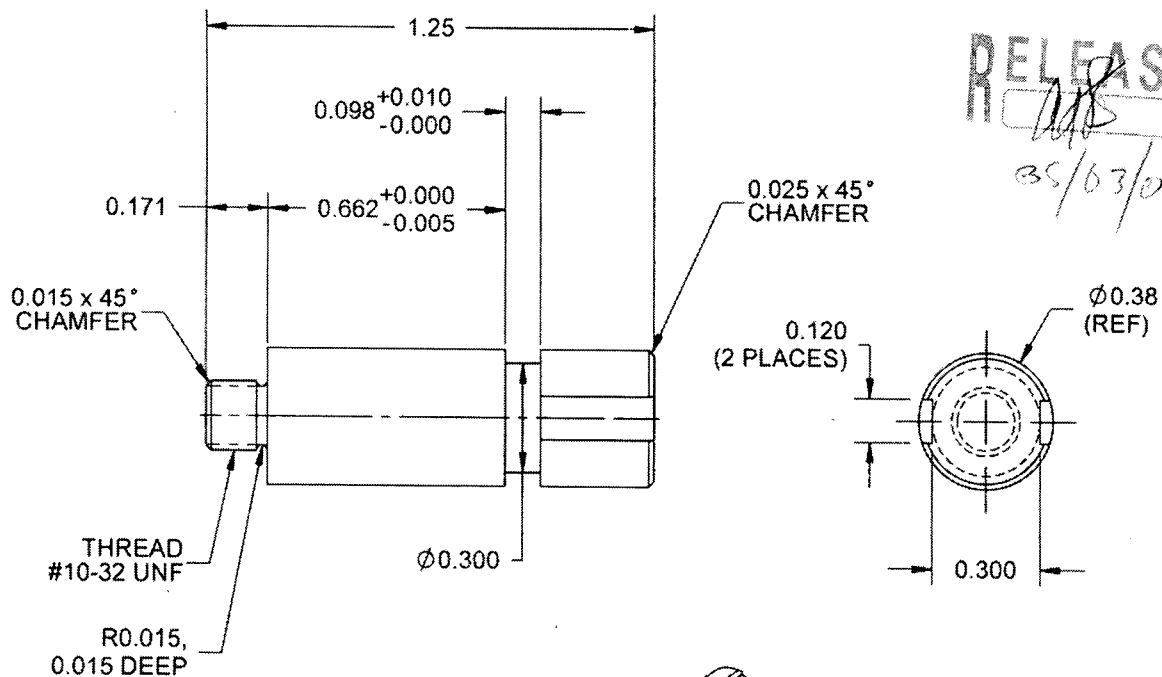
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NOTE: Date & initial all entries



77090

DESIGN 43	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7#	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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